

# Work Order ID 69318

Monday, May 09, 2011 8:47:11 AM



Page 1

Item ID: D2530

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Weldment

Start Date: 5/9/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

*M*

Date: 11-05-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2530	Rev B

100	Small Fab	0.00
Small Fab	Memo	0.00
Small Fab	1-Cut to length as per Dwg D2536 2-Debur	

10X *✓* M-1 11/05/25

110	QC6- Inspect dimensions to drawing	0.00
QC	Memo	0.00
Quality Control		

*11.06.02* (10)

120	Weld per dwg A/R S.S. rod Batch: 115928	0.00
Large Fab	Memo	0.00
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301	

*11.06.02*

10 *✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 11.06.03

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11.06.03

x10

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30  
320 9:00

10x 11/06/08

M 11 5/28

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 69318**

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Page 3

Item ID: D2530

Accept

Revision ID:

Item Name: Handle Weldment

Start Date: 5/9/2011 Start Qty: 10.00

Required Date: 5/12/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

10.00 BR 11-6-8.

170 Identify as per dwg &amp; Stock Location: 506 0.00



Packaging Memo 0.00

Packaging

11/6/8 SL (10)

180 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

11/6/9 JF  
MF  
11-06-08

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, May 09, 2011 8:47:18 AM

Page 1

Work Order ID: 69318

Parent Item: D2530

Parent Item Name: Handle Weldment



Start Date: 5/9/2011

Required Date: 5/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F  
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049  304 RD Tube .750 x .049W		Purchased	No			100	f	147.0086	2.9145	30.67895			
<div> <div>M 117797</div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> </div>													
MAT017 147.00863													
109314 9.333													
111619 3													
112187 4													
112800 11													
114852 2.75													
116108 3													
116720 1.833													
117030 32.09263													
117598 80													
D2534  Lock Plate		Manufactured	No			120	Each	12.0000	2	20			
<div> <div>WA019 369938</div> <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> </div>													
66807 12													
66807 12													

M-11/05/25  
30.67895

11.06.02  
20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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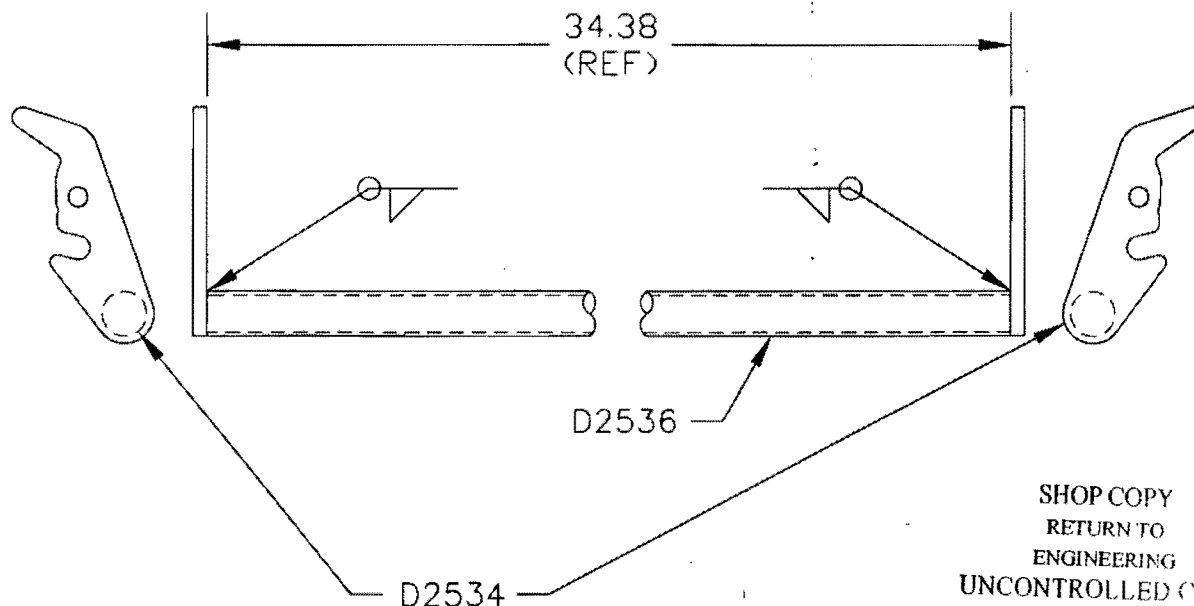
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2530	REV. B SHEET 1 OF 1
DATE 04.12.14	TITLE HANDLE WELDMENT		
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED

04.12.16 *[Signature]*PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 09313

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

*11-05-9*

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